

Date: Tuesday, 7/1/2008 2:33:31 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	ACCESS PANEL ASSEMBLY		
Job Number	40182			Part Number	D3245041		
Estimate Number	13008			Drawing Number	D3245 REV B		
P.O. Number				Project Number	N/A		
This Issue	7/1/2008	S.O. No.		Drawing Revision	B		
Prsh Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	7/28/2008	Qty:	4
Previous Run	35649			Um:	Each		
Written By	<u>ASAP</u> 07.01						
Checked & Approved By							
Comment	Est Rev A New Issue 07-09-11 JLM Verified By:EC						
	Est Rev:b ECN 1052 07-10-31 DD verified by: EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1		
	Pick Packing Kit		
2.0	D32451	Panel	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Panel		
	Batch: <u>35688</u>		
3.0	D32455	Door	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Angle Plate		
	Batch: <u>40202</u>		
4.0	235018C3Y	RIGID RECEPTACLE	
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)		
	RIGID RECEPTACLE		
	Batch: <u>40202 M106810</u>		
5.0	MS20427M33	Rivet	
	Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)		
	Rivet		
	Batch: <u>M108021</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:31 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 40182

Part Number: D3245041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20615M33

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Rivet

18235

(104 en stock) 8/9/08 JCL

7.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and D3245-5 angle as per Dwg D3245

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/08 (4)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with part# and batch# using fine point ink marker and Stock

Location: \_\_\_\_\_

8/08/08 (4)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/08 JCL

Job Completion



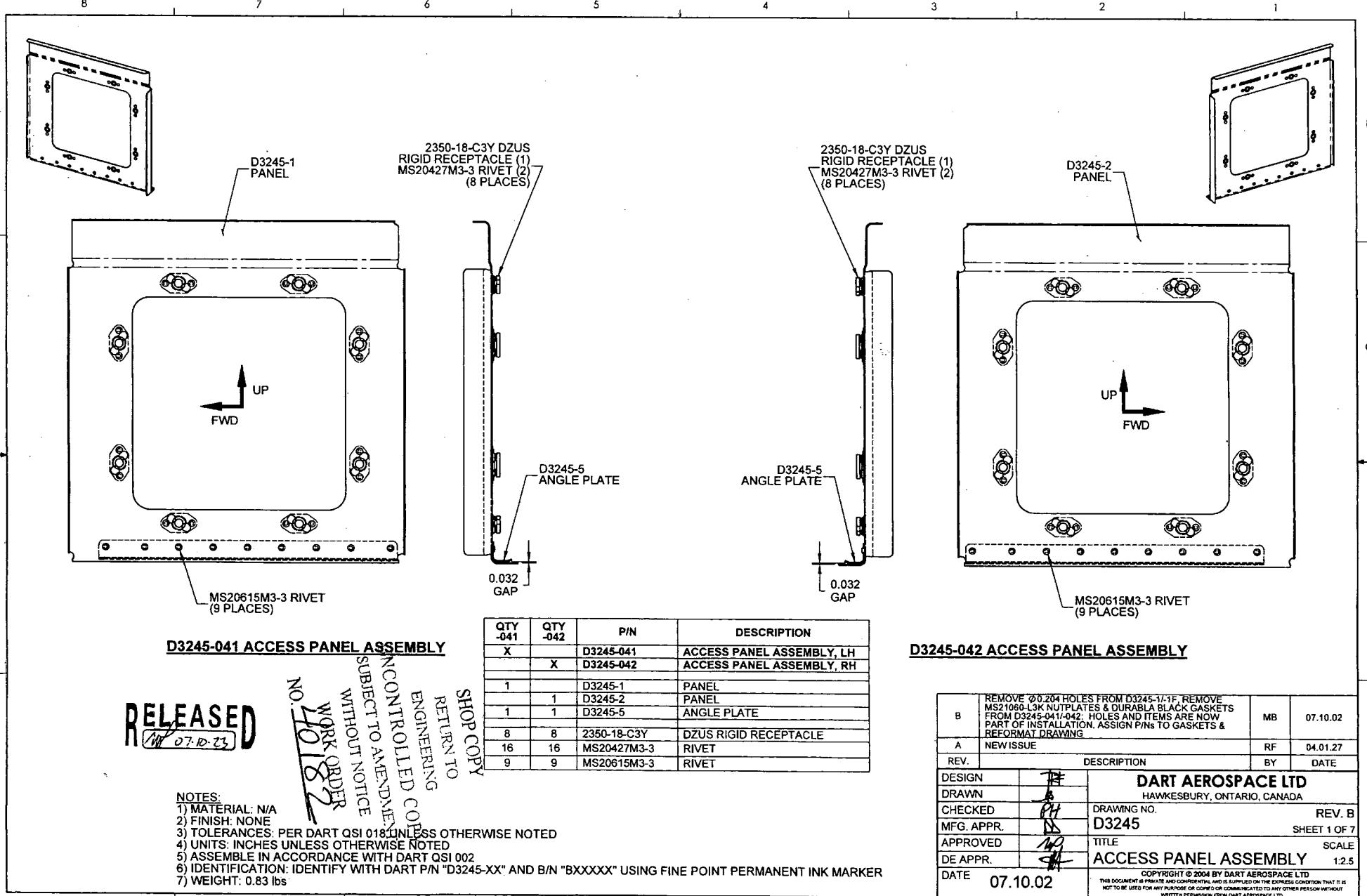
8/09/08 JCL

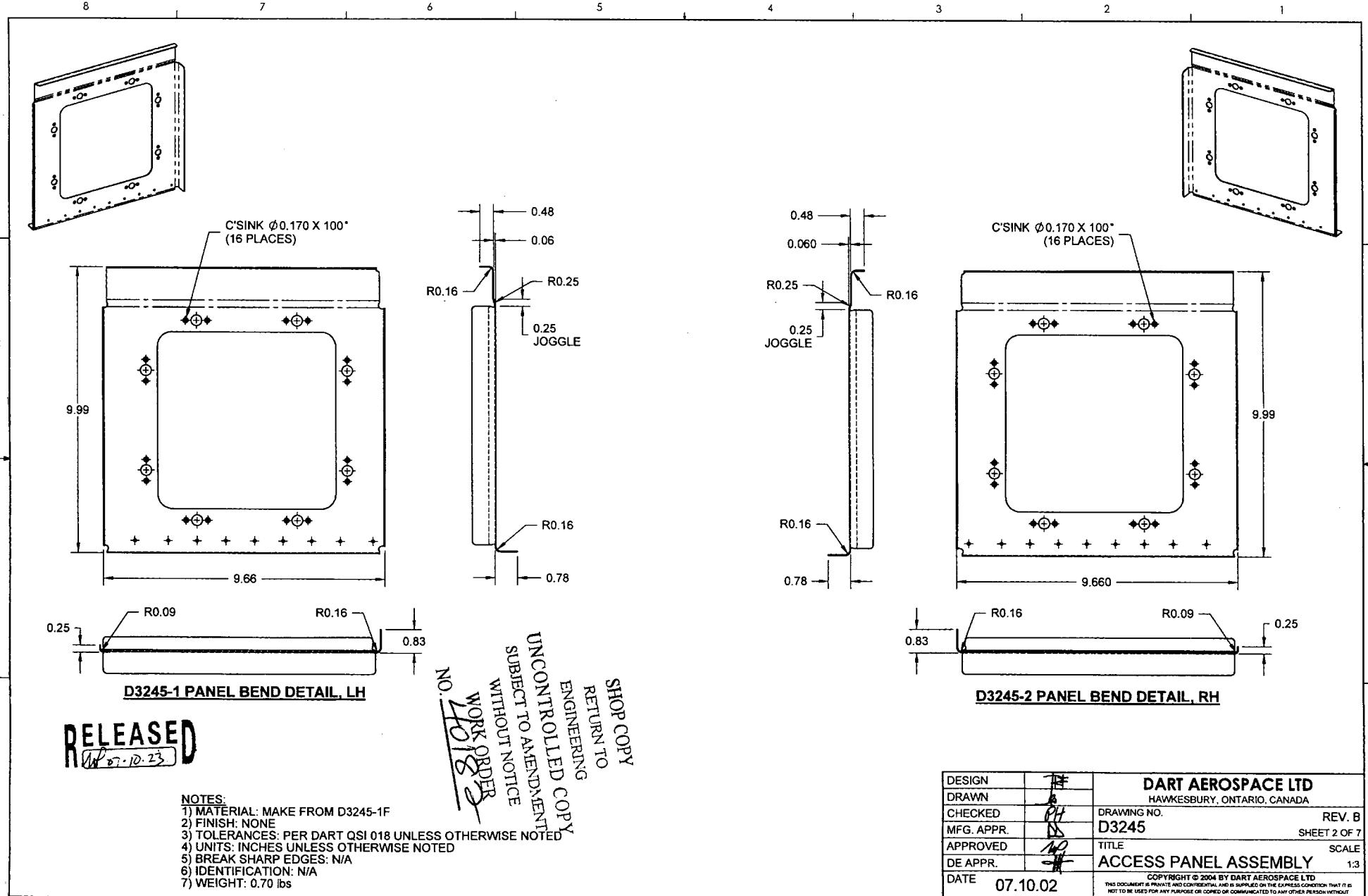
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

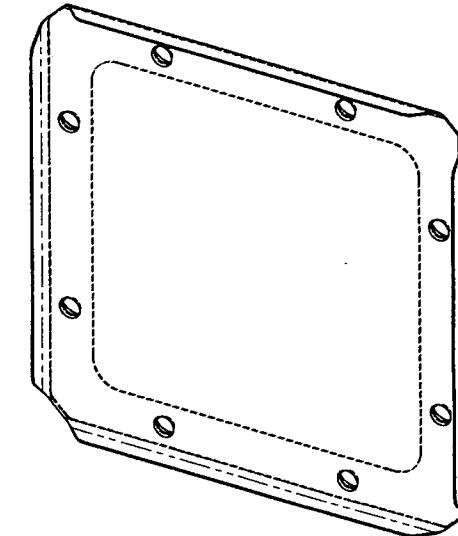
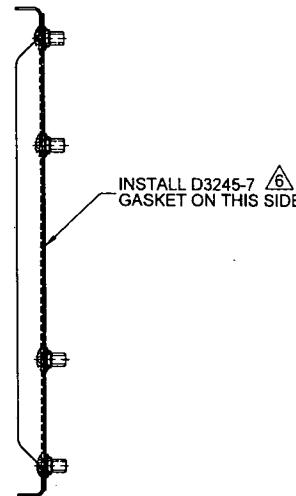
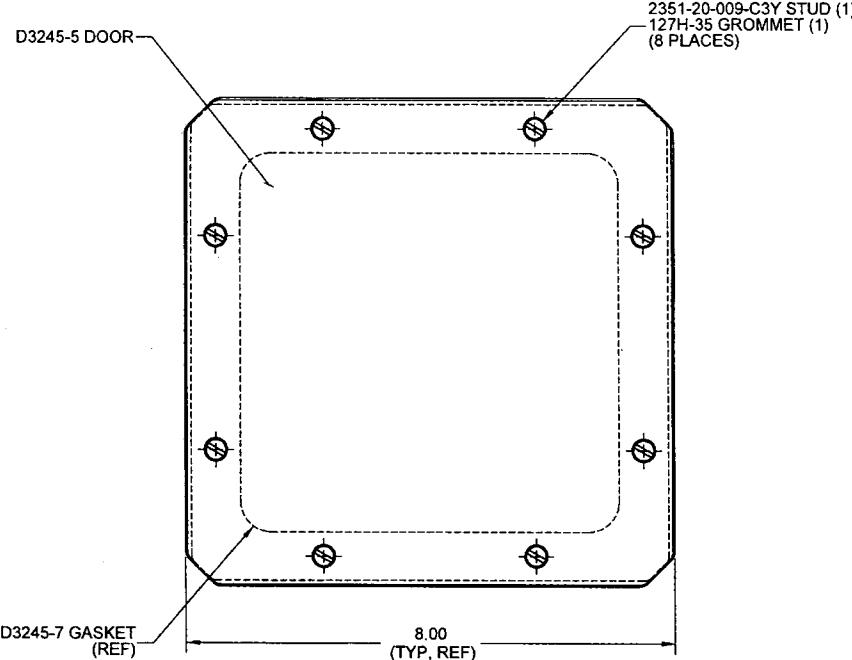
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





8 7 6 5 4 3 2 1

**D3245-043 DOOR ASSEMBLY**

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS  
 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002  
 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER  
 9) WEIGHT: 0.73 lbs

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 WORK ORDER NO. *2018*

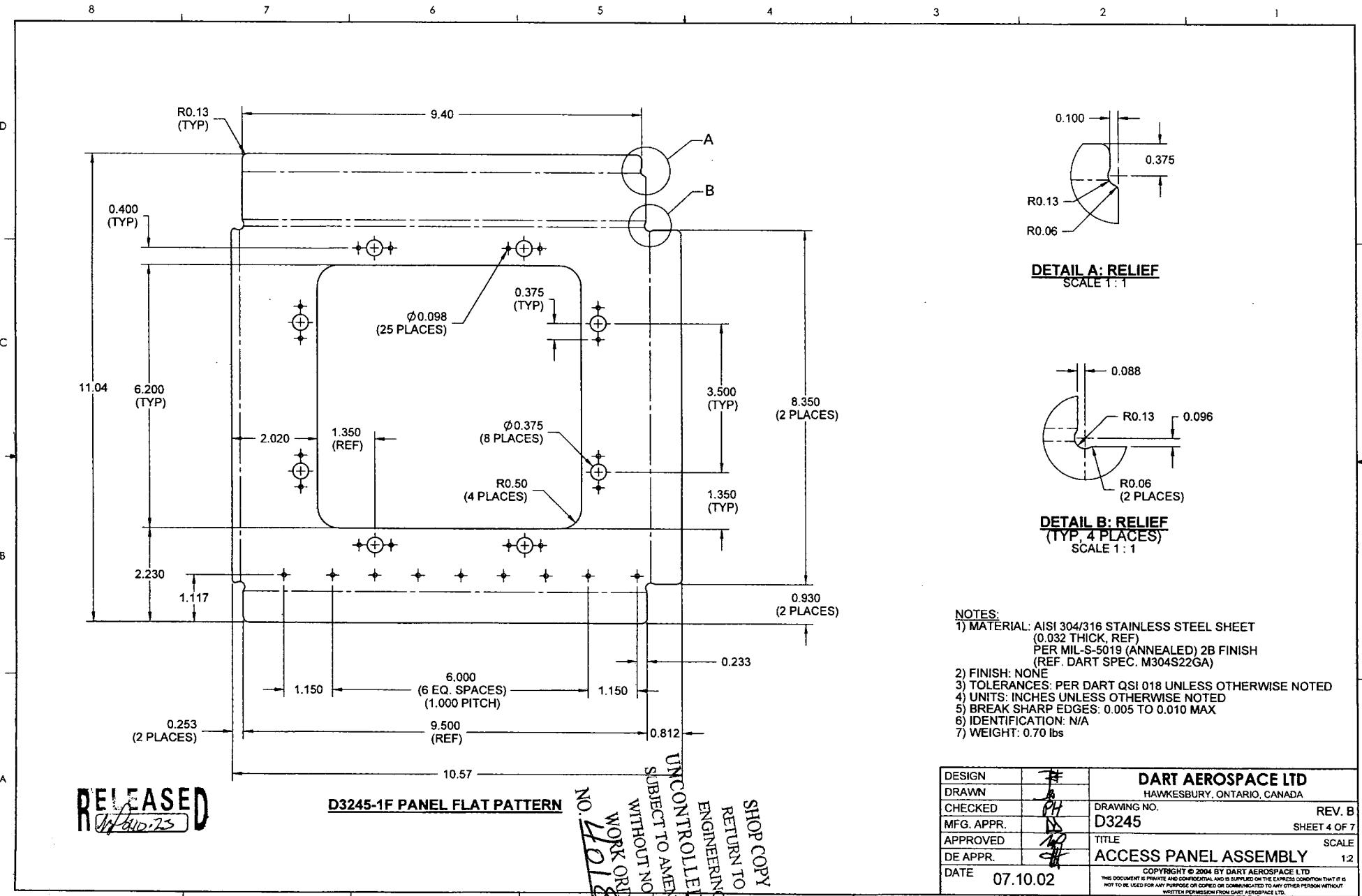
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DESIGN	<i>PF</i>	DART AEROSPACE LTD
DRAWN	<i>B</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. <i>D3245</i> REV. B
MFG. APPR.	<i>DL</i>	SHEET 3 OF 7
APPROVED	<i>MP</i>	TITLE <i>ACCESS PANEL ASSEMBLY</i> SCALE <i>12</i>
DE APPR.	<i>SH</i>	DATE <i>07.10.02</i>

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8 7 6 5 4 3 2 1

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MAY 17 2023

D3245-1F PANEL FLAT PATTERN

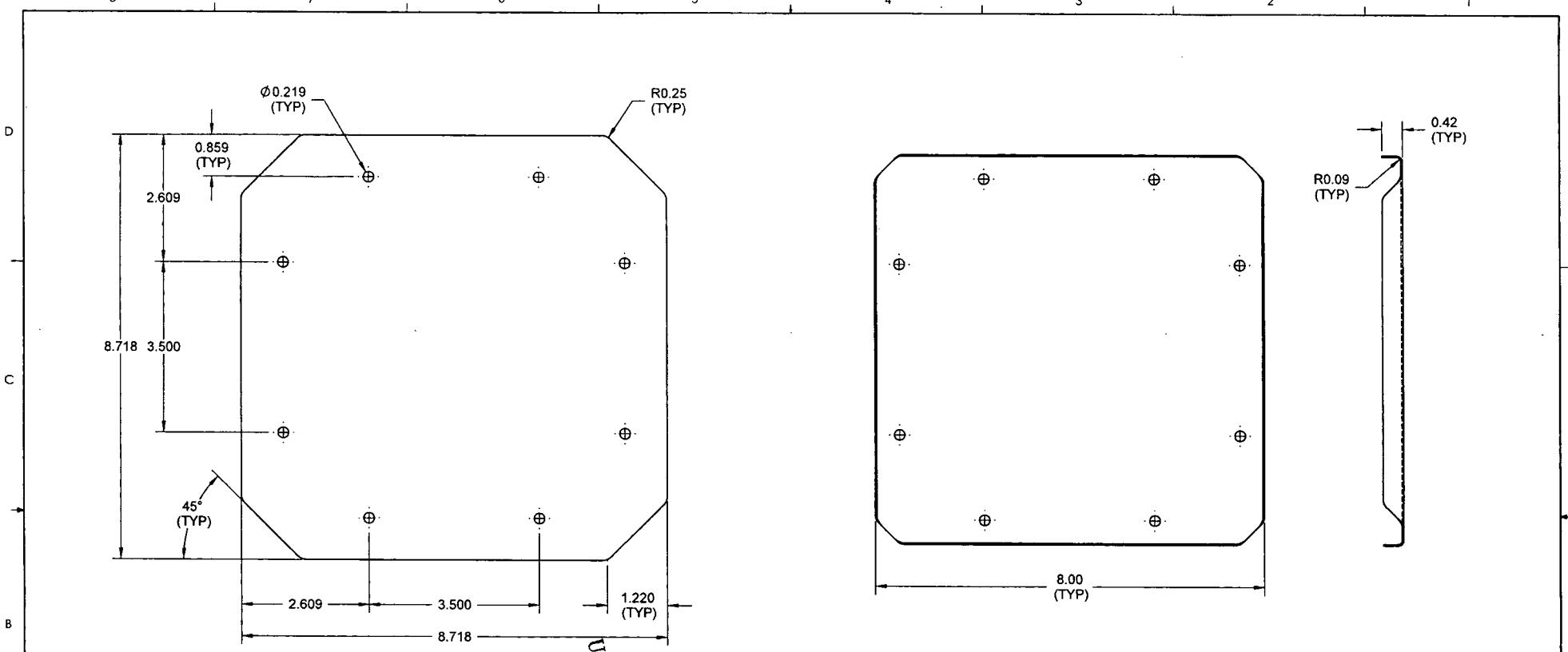
CONTROLLER SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 40182

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DESIGN	<u>F</u>	DART AEROSPACE LTD		
DRAWN	<u>B</u>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>PH</u>	DRAWING NO.	REV. B	
MFG. APPR.	<u>N</u>	D3245	SHEET 4 OF 7	
APPROVED	<u>MP</u>	TITLE	SCALE	
DE APPR.	<u>CH</u>	ACCESS PANEL ASSEMBLY 1:2		
DATE	07.10.02		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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D3245-3F DOOR FLAT PATTERN

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02/10/02

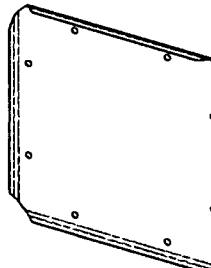
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07.10.02

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.67 lbs

D3245-3 DOOR BENDING DETAIL

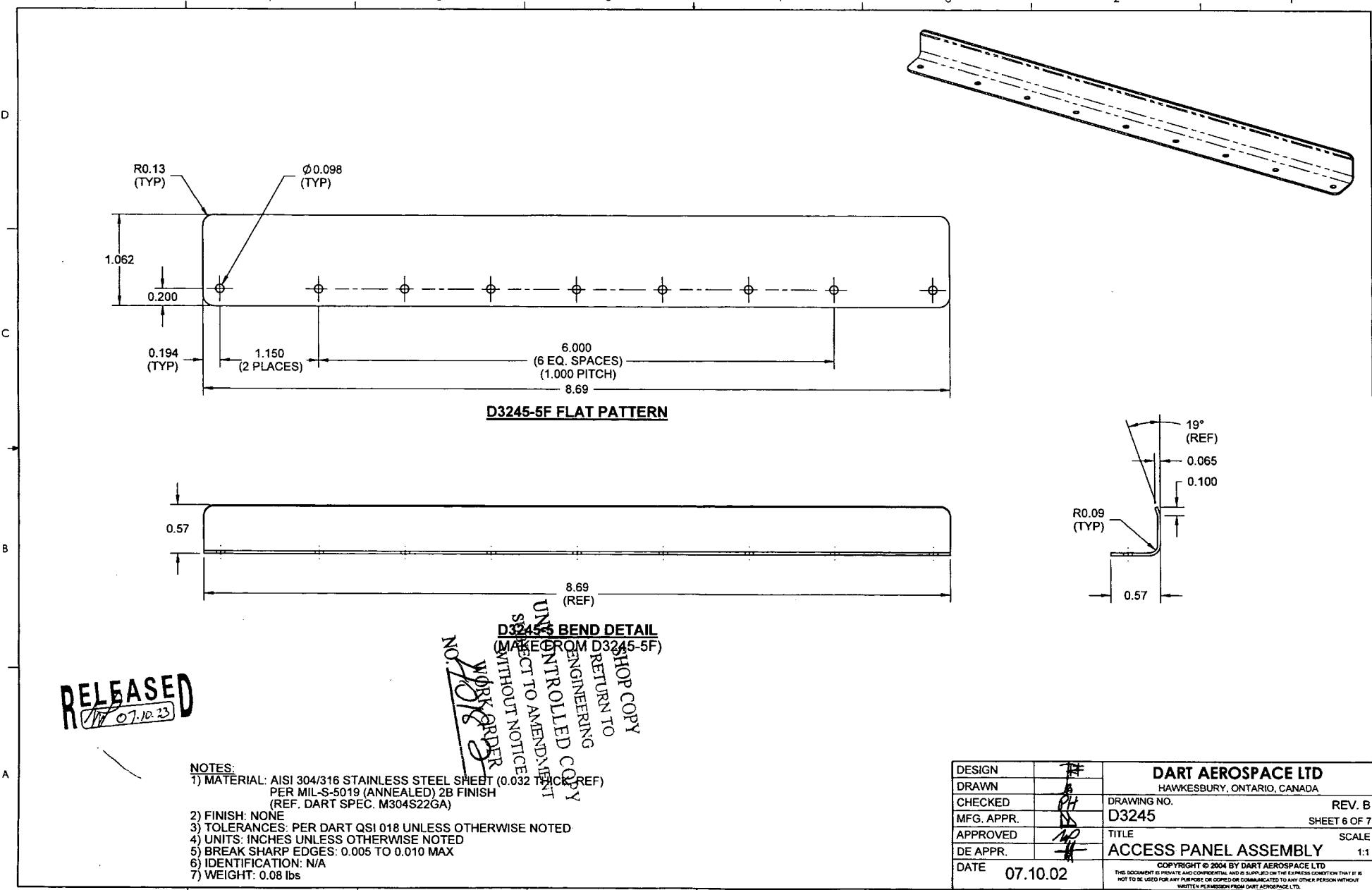


DESIGN	1F	DART AEROSPACE LTD
DRAWN	<u>16</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>PH</u>	DRAWING NO.
MFG. APPR.	<u>DS</u> <td>D3245</td>	D3245
APPROVED	<u>MM</u>	REV. B
DE APPR.	<u>MM</u>	SHEET 5 OF 7
DATE	07.10.02	SCALE
		ACCESS PANEL ASSEMBLY

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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

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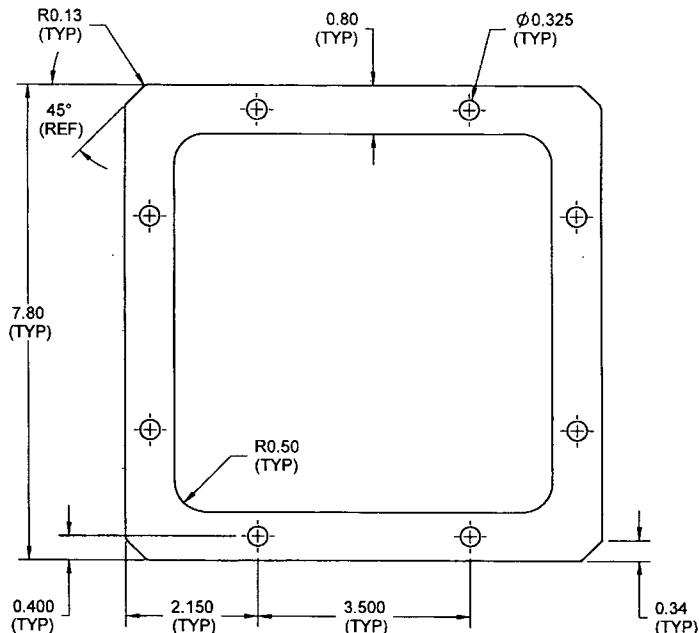
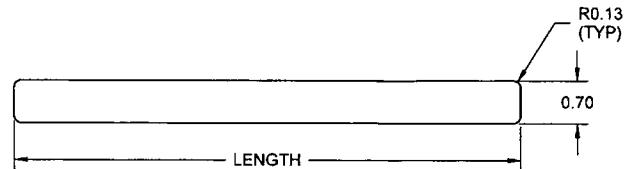
C

B

B

A

A

D3245-7 GASKETD3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

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07.10.02

NOTES:  
 1) MATERIAL: DURABLA BLACK GASKET, .035 THICK  
 (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: N/A

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 WORK ORDER  
 NO. 2

DESIGN	1	DART AEROSPACE LTD
DRAWN	b	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3245 REV. B
MFG. APPR.		SHEET 7 OF 7
APPROVED	AD	TITLE ACCESS PANEL ASSEMBLY
DE APPR.	CF	SCALE 1:2
DATE	07.10.02	

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